

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029597**Date Inspected:** 23-May-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** William Sherwood**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

At OBG panel point location PP97.5 west bound and PP108.5 east bound, ABF qualified welders Lin E Yun and Lou Xiao Hua were observed continuing to perform 3F (vertical) position fillet welding the barrier cover plate at the corner of luminaire light post box. The welders were noted fillet welding the plates using the Shielded Metal Arc Welding (SMAW) with 3.2mm diameter E7018H4R electrode implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-F1200A. The fillet welding of the barrier cover on the luminaire corner was welded per Caltrans approved drawing Barrier Details No. 2D. This QA Inspector had noted QC Inspector William Sherwood monitoring the welders' welding parameters and workmanship of the fillet welding being welded. This QA Inspector performed a verification of the welding parameters and observed working current of 130 amperes on the 3.2mm E7018H4R electrode. At the end of the shift, the welders have completed the 6mm fillet weld joints on four (4) corners of one luminaire boxes as mentioned were completed.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

At OBG panel point PP97.5 west bound, ASB welder Lou Xiao Hua was observed continuing to perform 3F (vertical) fillet welding the barrier cover plate for the corner of luminaire light post box.



Summary of Conversations:

No significant conversation occurred today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas 916-764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Lizardo, Joselito	Quality Assurance Inspector
Reviewed By:	Reyes, Danny	QA Reviewer
